

139769

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/7/2015 **Start Qty:** 3.00 ***3***

Cust Item ID:

Required Date: 12/24/2015 **Req'd Qty:** 3.00 ***3***

Customer:

Reference:

20151207

Approvals: Process Plan: SA Date: Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1003	B								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy bluefile & type labels per PPP D066-1003-011L08 CHG002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 139769***139769***

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Item ID: D066-1003-011L08

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: R66 Cabin Floor Protector - Clear

Stop ***NS2***

Start Date: 12/7/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 12/24/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00				3	27	28	
Packaging	Identify and pack for shipping as per PPP D066-1003-011L08						8-89	9-89	JAN 01 2016
	Location : FG117								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

MCS JAN 05 2016

MCS JAN 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

Picklist Print

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Work Order ID: 139769

139769

Parent Item: D066-1003-011L08

D066-1003-011L08

Parent Item Name: R66 Cabin Floor Protector - Clear

Start Date: 12/7/2015

Required Date: 12/24/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 14.02.05 NEW ISSUE DD VERF:JLM IPP Rev. B
14/07/02 Parts list updated. DL IPP REV:C 15.02.1 AS
PER IIN REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3580-3 Joggle Bracket		Manufactured	No				Each	29.0000	6	18			
**													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST043	29								
				133901	9								
				136061	20								
MS21059L3 Nut Plate		Purchased	No				Each	159.0000	6	18			
**													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				CA	16								
				M129682	16								
				cck007a	100								
				M133363	100								
				GA	1								
				113749	1								
				ST301	11								
				M133031	11								
				ST303	31								
				M131616	5								
				M133016	26								
D4941-1L08 Floor Protector, Fwd LH, (Clear)		Manufactured	No				Each	0.0000	1	3			
**													

DAS
28
9-89

DEC 22 2015

DAS
27
9-89

Picklist Print

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Work Order ID: 139769

139769

Parent Item: D066-1003-011L08

D066-1003-011L08

Parent Item Name: R66 Cabin Floor Protector - Clear

Start Date: 12/7/2015

Required Date: 12/24/2015

Start Qty: 3.00

Required Qty: 3.00

D4941-2L08

DAS
28
9-89

Manufactured No

Each

0.0000

1 3

**

139776

DAS
6
9-89

3 *D4941-2L08*

Floor Protector, Fwd RH, (Clear)

D4941-3L08

Manufactured No

Each

0.0000

1 3

**

139775

DAS
6
9-89

3 *D4941-3L08*

Floor Protector, Aft LH, (Clear)

D4941-4L08

Manufactured No

Each

0.0000

3

**

139777

DAS
6
9-89

3 *D4941-4L08*

Floor Protector, Aft RH, (Clear)

AN525-10R8

DAS
28
9-89

Purchased No

Each

46.0000

6 18

**

3 *AN525-10R8*

Screw

DAS
28
9-89LocationLoc QtyLoc Code

ST329

46

m129163

46

Each

3,268.000

12 36

**

DAS
6
9-89

MS20426AD3-4

Purchased No

3 *MS20426AD3-4*

RIVET

LocationLoc QtyLoc Code

GA

3109

m131697

3109

ST312

159

m127432

159

DAS
28
9-89DAS
6
9-89
DEC 22 2015

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Shop Packet Print

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4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the D066-1003-XXX kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1003-011L02 Cabin Floor Protector (Black Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-011L08 Cabin Floor Protector (Clear Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-013 Baggage Compartment Protectors	16.5 lb 7.5 kg	3.29 in 0.08 m	54 in-lb 0.60 m-kg	104.35 in 2.65 m	1721 in-lb 19.88 m-kg

5.0 PARTS LIST

Qty -011 L02	Qty -011 L08	Qty -013	Part Number	Description
X			D066-1003-011L02	CABIN FLOOR PROTECTORS (BLACK)
	X		D066-1003-011L08	CABIN FLOOR PROTECTORS (CLEAR)
		X	D066-1003-013	BAGGAGE COMPARTMENT PROTECTORS
1			D4941-1L02	FLOOR PROTECTOR, FWD LH
	1		D4941-1L08	FLOOR PROTECTOR, FWD LH
1			D4941-2 L02	FLOOR PROTECTOR, FWD RH
	1		D4941-2 L08	FLOOR PROTECTOR, FWD RH
1			D4941-3 L02	FLOOR PROTECTOR, AFT LH
	1		D4941-3 L08	FLOOR PROTECTOR, AFT LH
1			D4941-4 L02	FLOOR PROTECTOR, AFT RH
	1		D4941-4 L08	FLOOR PROTECTOR, AFT RH
		1	D4942-1	FLOOR PROTECTOR
		1	D4942-3	FORWARD WALL PROTECTOR
		1	D4942-7	LH WALL PROTECTOR
		1	D4942-9	DOOR PROTECTOR
		2	D4967-1	BRACKET
6	6		D3580-3	JOGGLE BRACKET
		3	D3580-5	JOGGLE BRACKET
		1	D5119-1	PLACARD
		1	D5120-1	PLACARD
6	6		AN525-10R8	SCREW
		10	AN525-10R9	SCREW
		8	CS62-1032-8CR	STUD, CLICK BOND
		3	AN970-3	WASHER
		8	MS21042-3	NUT, SELF LOCKING
		5	CB 200	3.5G ACRYLIC ADHESIVE
6	6	10	MS21059L3	NUTPLATE
12	12	20	MS20426AD3-4	RIVET